

Date:  
User:Thursday, 18/09/2008 11:12:36 AM  
Julie Lecocq

## Process Sheet

Smith

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WELDMENT TOP PANEL
Job Number	: 42095		
Estimate Number	: 13029		
P.O. Number	:	Part Number	: D36503
This Issue	: 18/09/2008 S.O. No. :	Drawing Number	: D3650 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 39933	Material	:
Written By	:	Due Date	: 25/09/2008
Checked & Approved By	: <u>JD 08.9.18</u>	Qty:	3 Um: Each
Comment	Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD Est Rev:C ecn1162 08-04-02 DD verified by: EC		

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 1.2023 sf(s)/Unit Total: 6.0113 sf(s)  
 304/316 SS sheet 26 ga (0.018" thick)  
 Batch: 108775 IB 8-9-26

2.0 WATER JET 109398 FLOW WATER JET

Comment: FLOW WATER JET  
 1-Cut as per Dwg D3650  
 Dwg Rev: B IB 8-9-26  
 Prog Rev: B

2-Deburr if necessary IB 8-9-26

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE  
 Form as per Dwg D3650

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Thursday, 18/09/2008 11:12:36 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 42095

Part Number: D36503

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/22 (X3)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

N/A

8.0

D365011

Filler Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

FILLER PLATE

batch

B 39949 → 12 B 40044 → 12

B 43820 → 1

P 09.02.03

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1-trim to fit (D3650-11)

2-Weld assembly as per dwg D3650 QSI004

3-grind weld smooth if necessary

P 09.02.03 (X3)

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

P 09.02.03 (3)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/03 (X3)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: \_\_\_\_\_

ST 190

MF 09-02-03

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/04

MF 09-02-03

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42095
<b>Description:</b> Center Panel		<b>Part Number:</b> D3650-3
<b>Inspection Dwg:</b> D3650	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.221	+0.005/-0.001	.226	*			
Ø0.213	+0.005/-0.001	.217	*			
0.40	+/-0.030	.415	*			
15.45	+/-0.030	15.45	*			
10.49	+/-0.030	10.49	*			
15.53	+/-0.030	15.53	*			
11.99	+/-0.030	11.99	*			
12.90	+/-0.030	12.85	*			
4.300	+/-0.010	4.300	*			
12.09	+/-0.030	12.09	*			
13.06	+/-0.030	13.06	*			
1.943	+/-0.010	1.943	*			
5.884	+/-0.010	5.883	*			
8.248	+/-0.010	8.251	*			
9.196	+/-0.010	9.196	*			
13.80	+/-0.030	13.80	*			
2.28	+/-0.030	2.28	*			
7.19	+/-0.030	7.195	*			
9.55	+/-0.030	9.55	*			
10.65	+/-0.030	10.65	*			
3.35	+/-0.030	3.350	*			

<b>Measured by:</b> IR	<b>Audited by:</b> S. S. 08/09/26	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-9-26	<b>Date:</b> 08/09/26	<b>Date:</b>	N/A

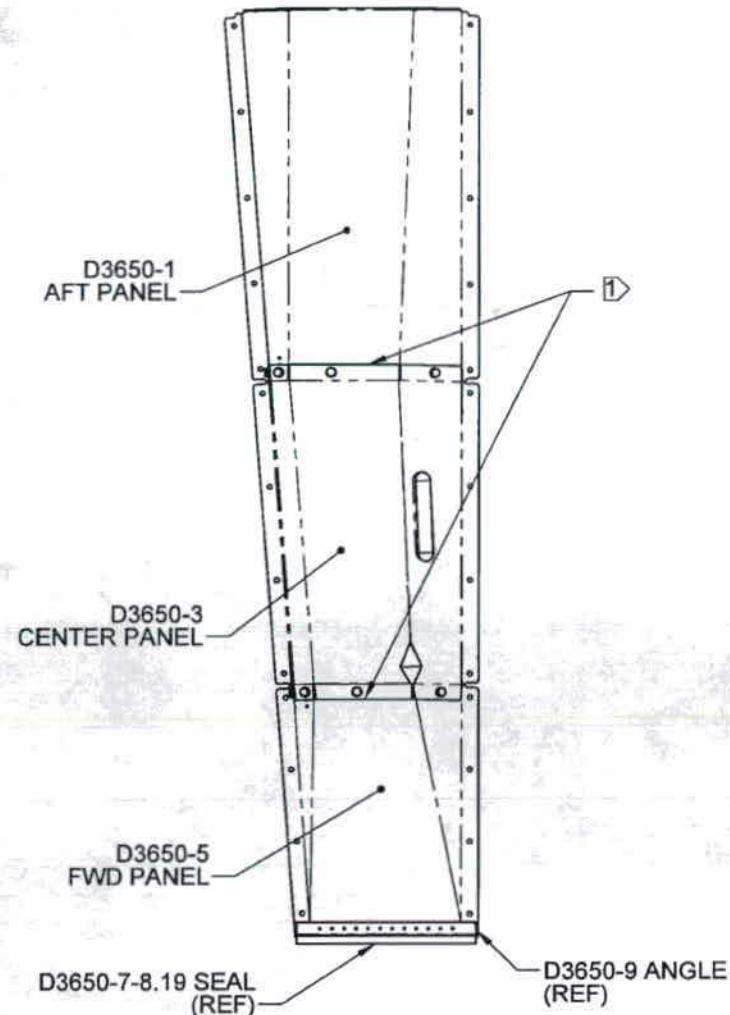
Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	IR

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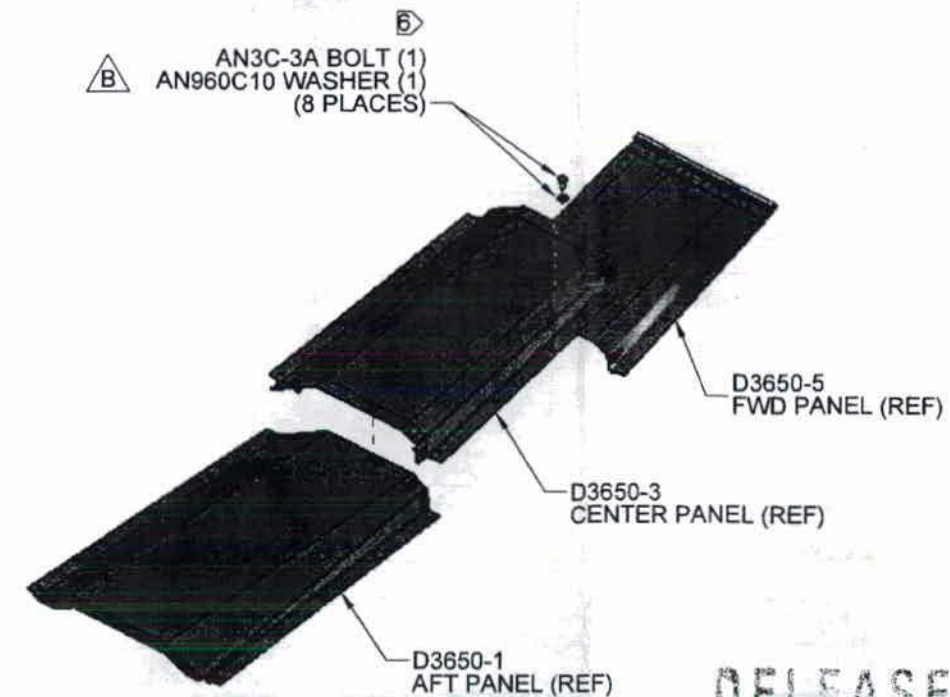




- NOTES:
- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
  - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 5) IDENTIFICATION: NONE
  - 6) TORQUE FASTENERS 15 TO 25 in-lb
  - 7) WEIGHT: 3.3 lbs



### D3650-041 TUNNEL TOP PANEL ASSEMBLY



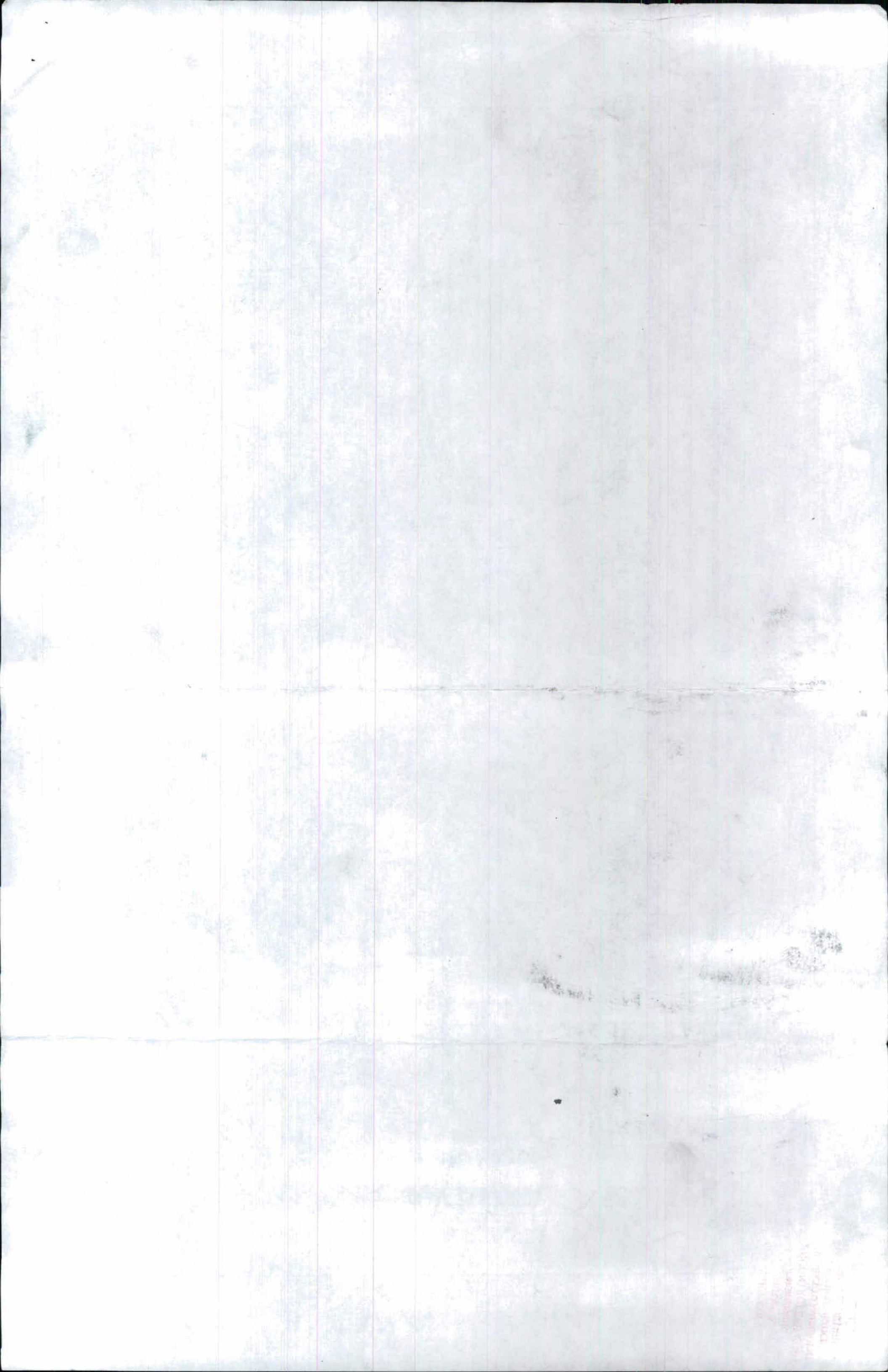
#### PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER

B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11/-11F TO SHEET 9; ADDED DETAIL 1 SHEET 9: RELOCATED D3650-11/-11F FROM SHEET 6; UPDATED DIMS OF D3650-11/-11F		RF	08.01.07
	A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	LE	DRAWING NO.	REV. B	
MFG. APPR.		D3650	SHEET 1 OF 9	
APPROVED		TITLE	SCALE	
DE APPR.		TOP PANEL ASSEMBLY	1:8	
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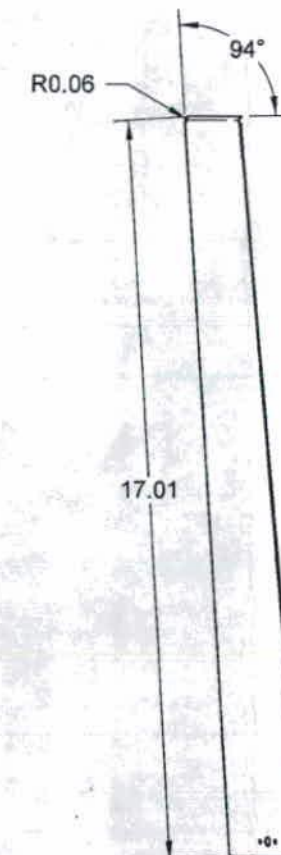
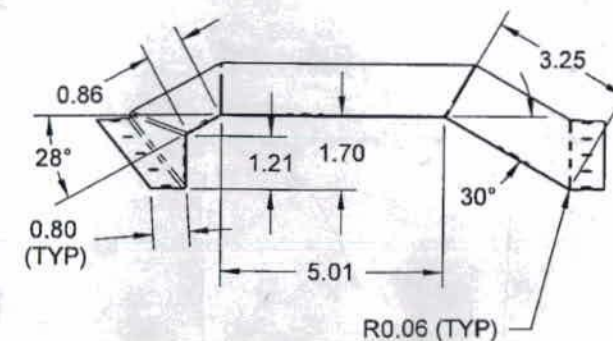
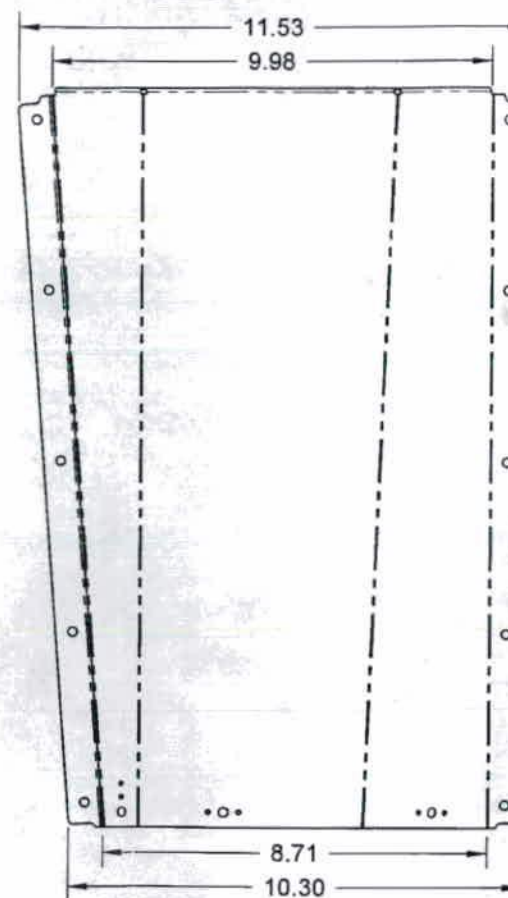
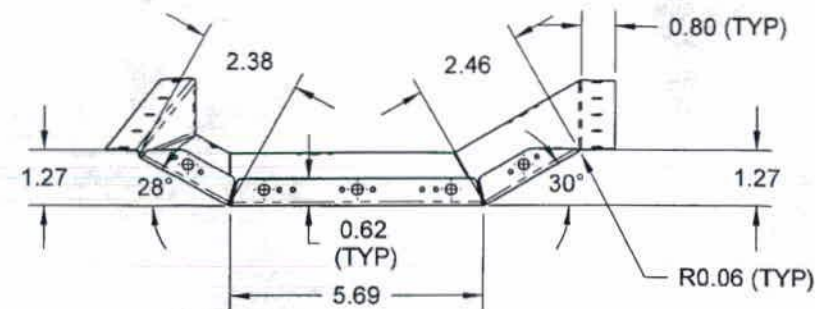
**D3650-1 AFT PANEL**

**PART LIST**

QTY -1	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE

**NOTES:**

- 1) FINISH: NONE
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) WEIGHT: 1.3 lbs



**D3650-1B AFT PANEL BENT PART**  
(MAKE FROM D3650-1F FLAT PATTERN)

RELEASED  
08-03-27

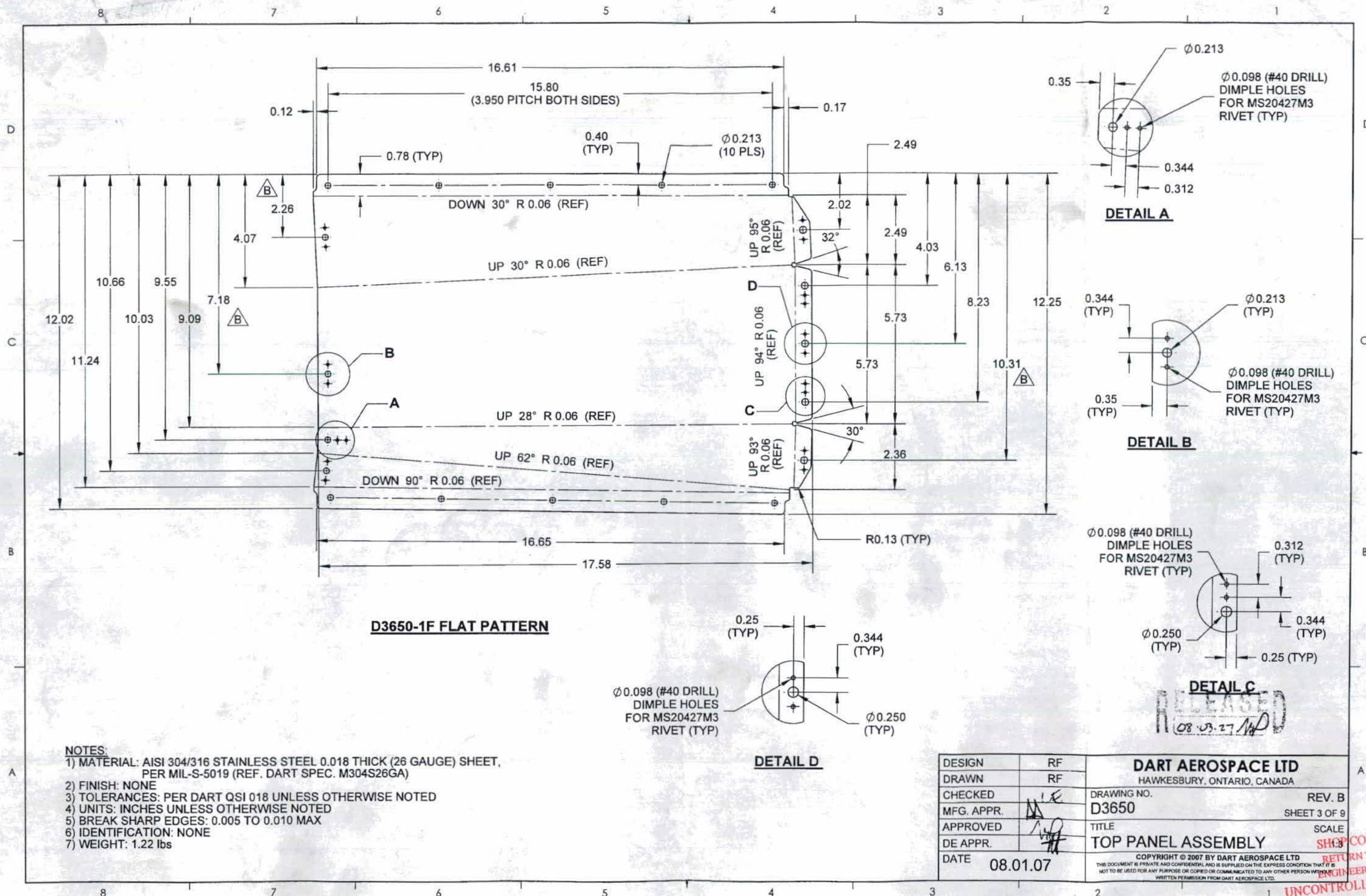
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:4
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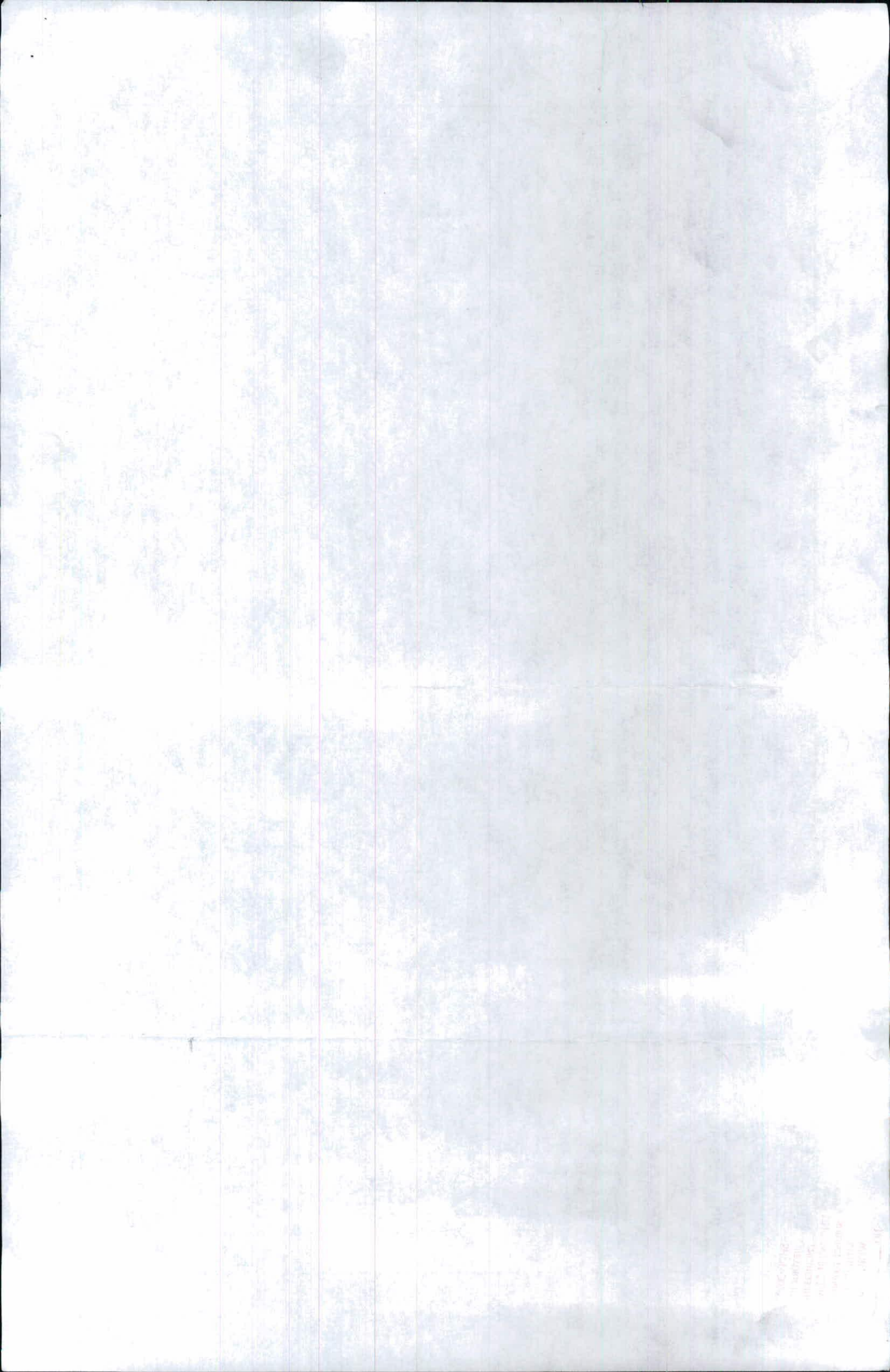


- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 1.22 lbs

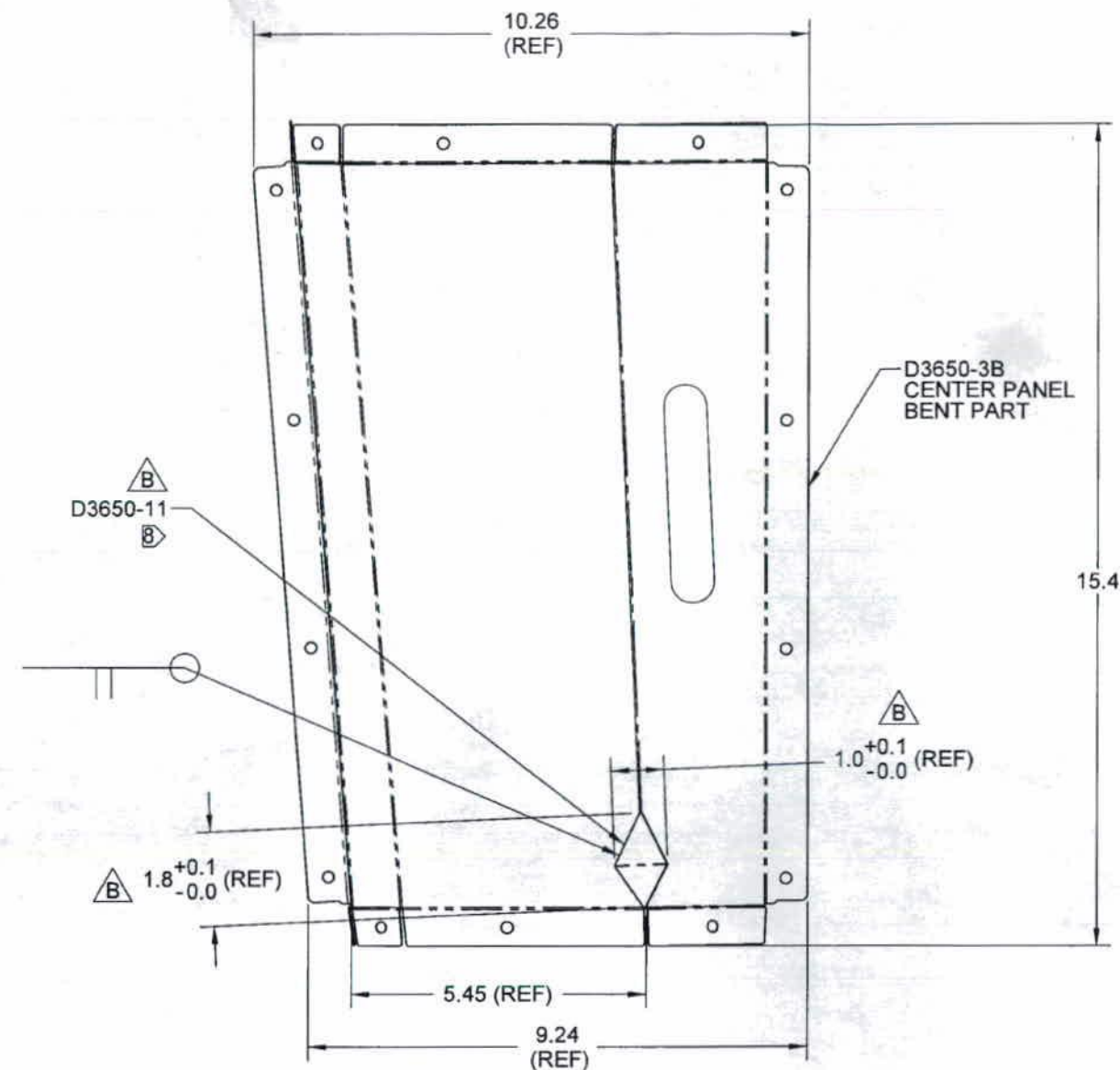
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>1.2</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>NA</i>	D3650	SHEET 3 OF 9
APPROVED	<i>WJH</i>	TITLE	SCALE
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**D3650-3 CENTER PANEL**



**PART LIST**

QTY	PART NUMBER	DESCRIPTION
3	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE

**NOTES:**

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.0 lb
- 8) TRIM D3650-11 TO FIT AS REQUIRED

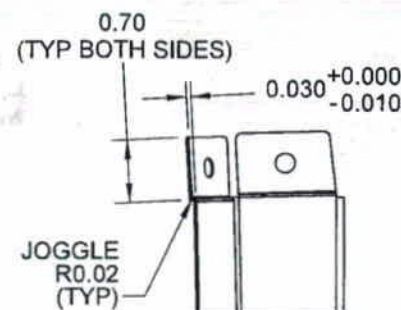
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MFG. APPR.		D3650	SHEET 4 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:3
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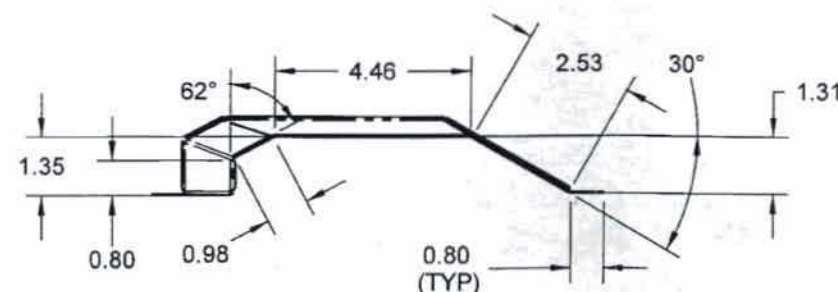
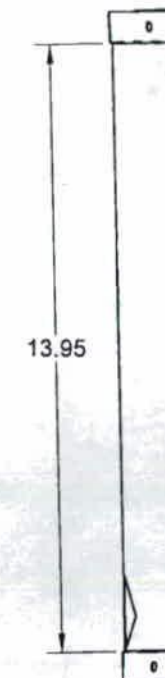
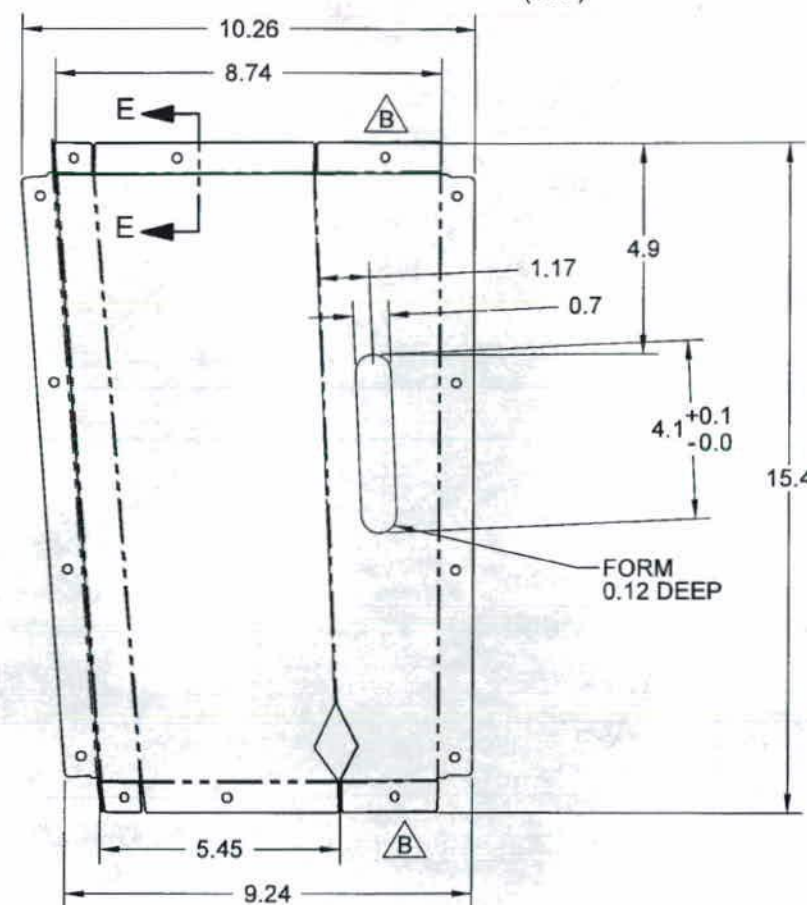
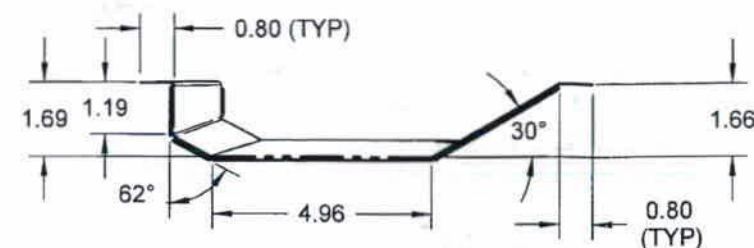
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**SECTION E-E**



- NOTES:**  
 1) FINISH: NONE  
 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 3) UNITS: INCHES UNLESS OTHERWISE NOTED  
 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 5) IDENTIFICATION: NONE

**D3650-3B CENTER PANEL BENT PART**  
 (MAKE FROM D3650-3F FLAT PATTERN)

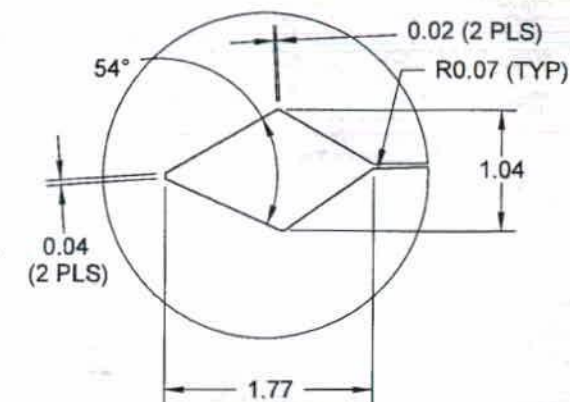
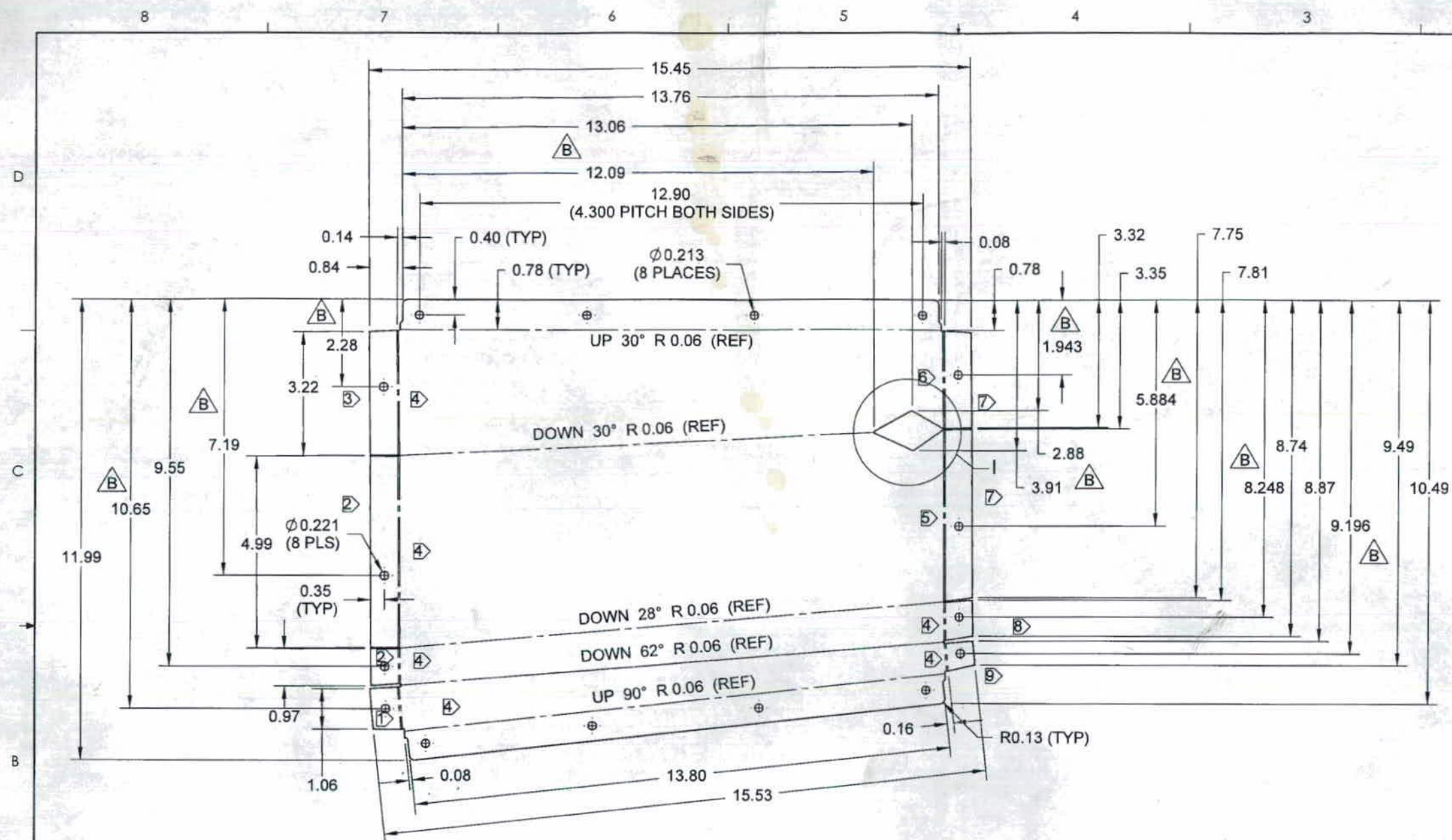
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 5 OF 9
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DE APPR.		TOP PANEL ASSEMBLY	1:1
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**DETAIL I**

- ① DOWN 92° R 0.015
- ② DOWN 89° R 0.015
- ③ DOWN 86° R 0.015
- ④ UP 90° R 0.015
- ⑤ UP 88° R 0.015
- ⑥ UP 90° R 0.015
- ⑦ DOWN 88° R 0.015
- ⑧ DOWN 90° R 0.015
- ⑨ DOWN 94° R 0.015

### D3650-3F CENTER PANEL FLAT PATTERN

D3650-3F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,  
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3650</b>  TITLE <b>TOP PANEL ASSEMBLY</b>  COPYRIGHT © 2007 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT</small>	REV B
DRAWN	RF		SHEET 6 OF 9
CHECKED	CE		SCALE
MFG. APPR.			FIN 13
APPROVED			UNCON
DE APPR.			
DATE	08.01.07		

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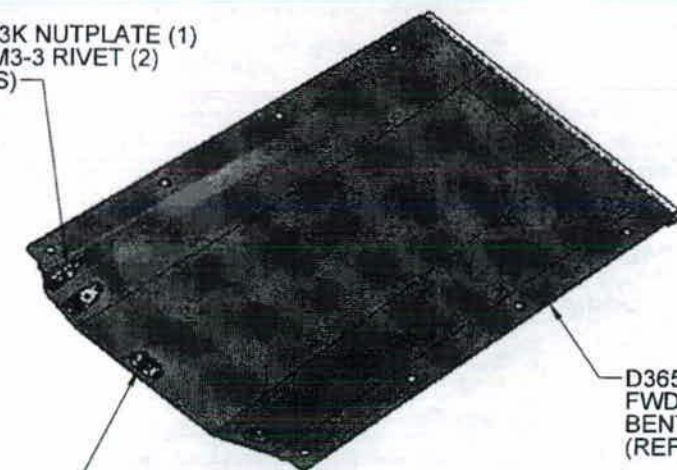
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MS21062-3K NUTPLATE (1)  
MS20427M3-3 RIVET (2)  
(2 PLACES)



MS21060-3K NUTPLATE (1)  
MS20427M3-3 RIVET (2)  
(2 PLACES)

#### PART LIST

QTY -5	PART NUMBER	DESCRIPTION
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	AN960C4	WASHER
12	CR3523-4-03 or NAS9307M-4-03	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

#### NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs

AN960C4 WASHER (REF)

0.07

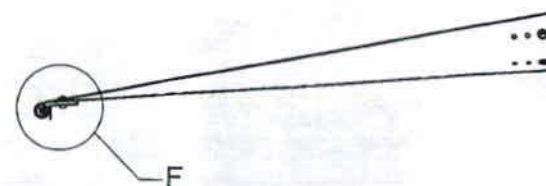
0.74

D3650-5B FWD PANEL  
BENT PART (REF)

D3650-7-8.19 SEAL (1)  
D3650-9 ANGLE (1)

CR3523-4-03 OR (NAS9307M-4-03)  
RIVET (REF)

#### DETAIL F



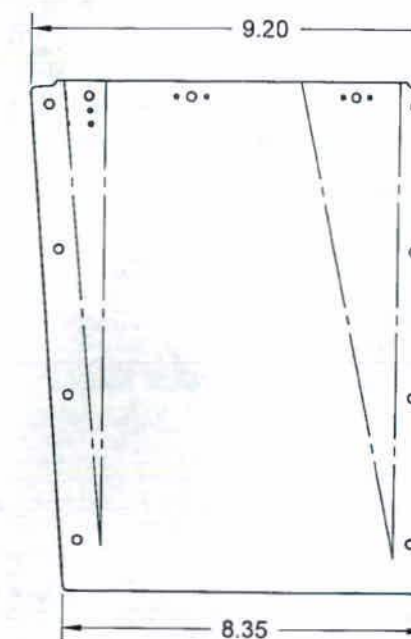
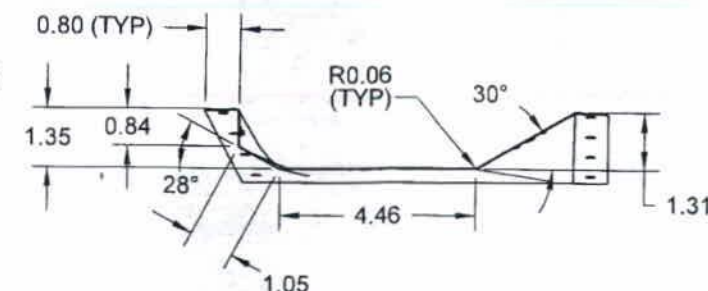
D3650-9 (REF)

D3650-7-8.19  
(REF)

D3650-5B  
FWD PANEL  
BENT PART

CENTRE D3650-7/-9 ON D3650-5B &  
TRANSFER  $\phi 0.129$  (#30 DRILL) HOLES  
FROM D3650-9 TO D3650-7 & D3650-5B  
AS SHOWN  
INSTALL  
CR3523-4-03 OR NAS9307M-4-03 RIVET (1)  
AN960C4 WASHER (1)  
(12 PLACES)

#### D3650-5 FWD PANEL



#### D3650-5B FWD PANEL BENT PART (MAKE FROM D3650-5F FLAT PATTERN)

RELEASED  
080327/WP

DESIGN	RF	<b>DART AEROSPACE LTD</b>
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	LE	DRAWING NO. <b>D3650</b>
MFG. APPR.		REV. B
APPROVED		SHEET 7 OF 9
DE APPR.		SCALE 1:1
DATE	08.01.07	TITLE <b>TOP PANEL ASSEMBLY</b>

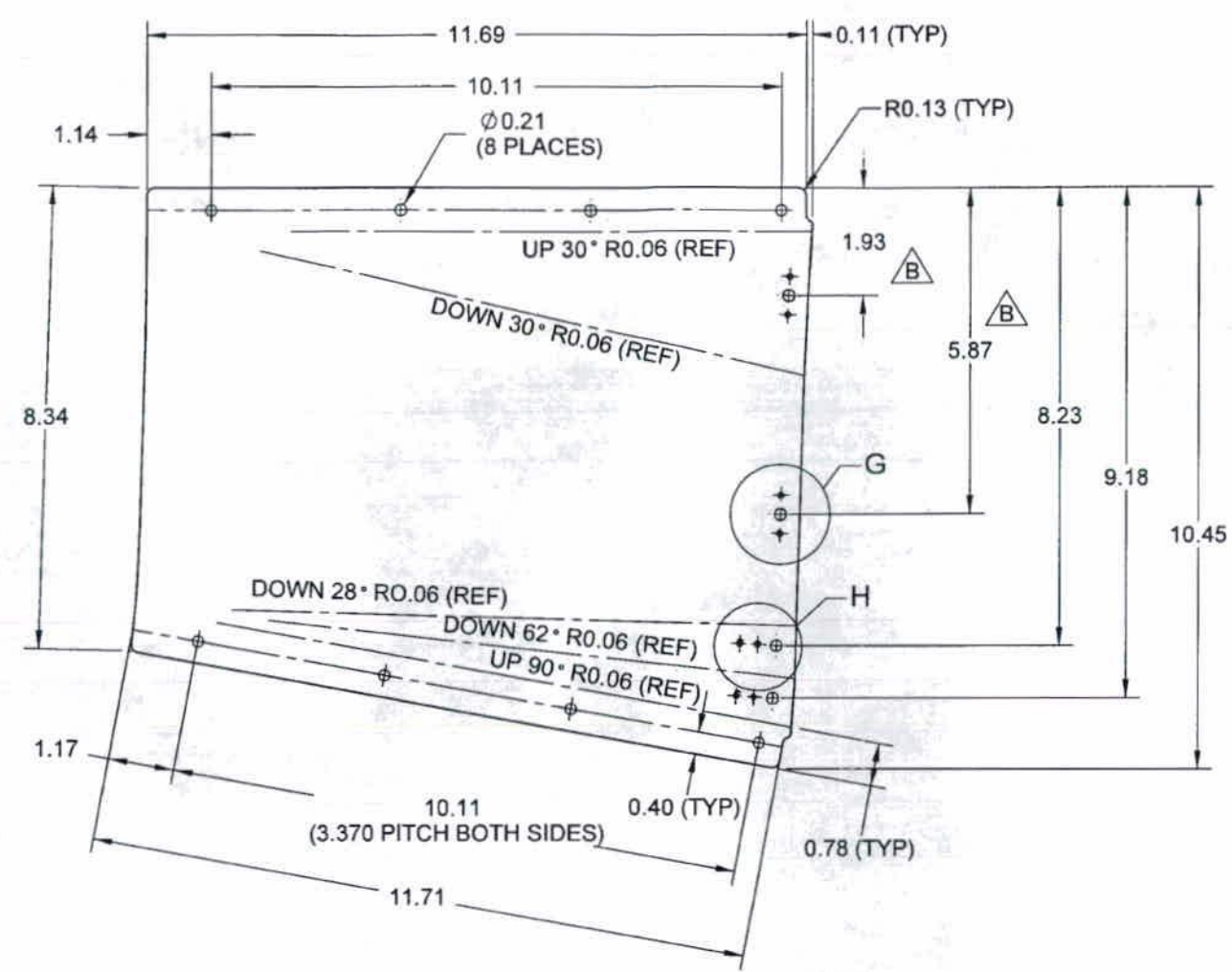
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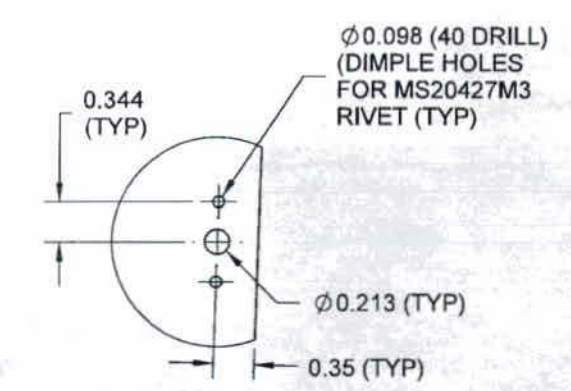
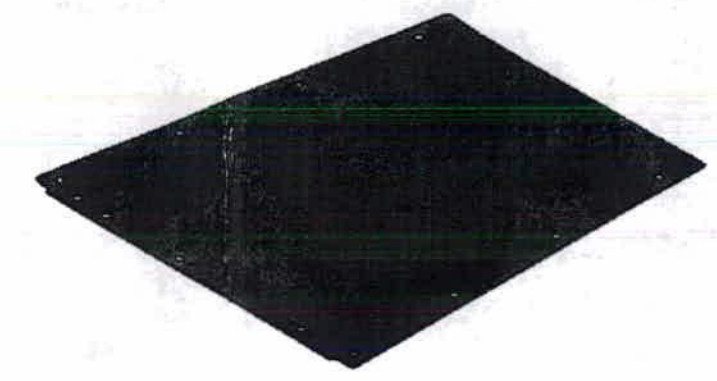




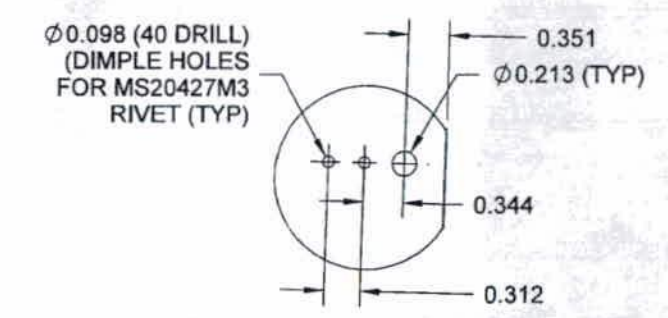




**D3650-5F FLAT PATTERN**



**DETAIL G**  
(2 PLS)



**DETAIL H**  
(2 PLS)

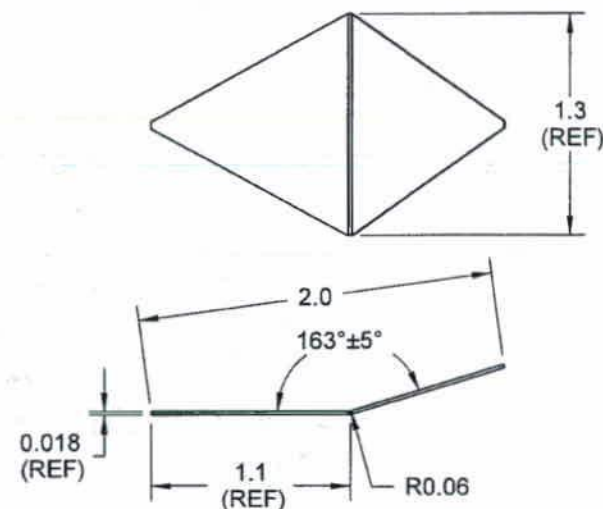
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.6 lb

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. B
MFG. APPR.	DA	D3650	SHEET 8 OF 9
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	TOP PANEL ASSEMBLY	1:3
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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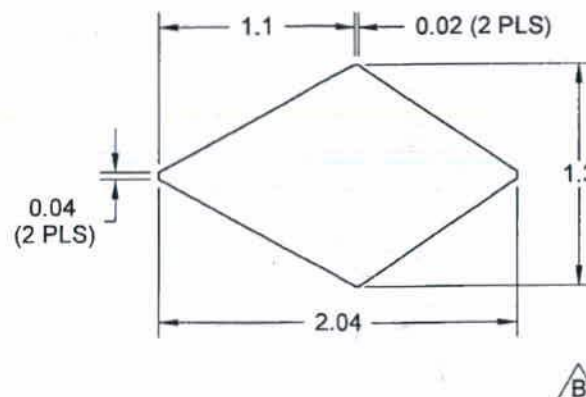
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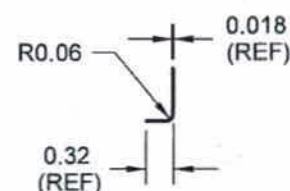




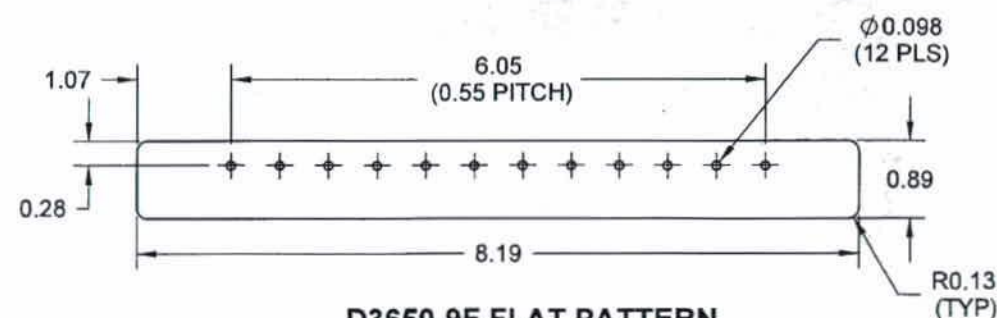
**D3650-11 FILLER PLATE**  
(MAKE FROM D3650-11F FLAT PATTERN)  
(SCALE 1:1)



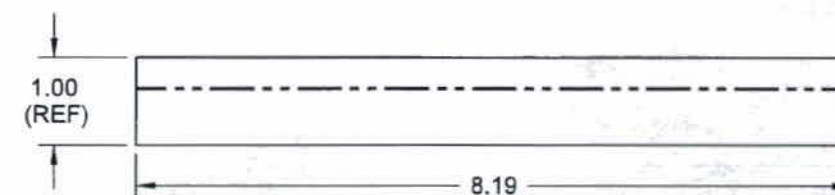
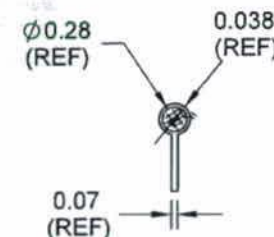
**D3650-11F FLAT PATTERN**  
(SCALE 1:1)



**D3650-9 ANGLE**  
(MAKE FROM D3650-9F FLAT PATTERN)



**D3650-9F FLAT PATTERN**



**D3650-7-8.19 SEAL**

**D3650-7-8.19 NOTES:**

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)  
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX  
WHERE X.XX = LENGTH IN INCHES  
EG. 12.50" LONG = D3650-7-12.50

**D3650-9 & D3650-11 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,  
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb  
D3650-11 WEIGHT: 0.007 lb

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MA	D3650	SHEET 9 OF 9
APPROVED	CH	TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	12
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